Thursday, 2/22/2007 2:57:28 PM date: User: Kim Johnston **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : BUSHING Customer Job Number : 30811 : 10175 **Estimate Number** : D2570 Part Number :WA P.O. Number S.O. No. : NA · D2570 REV A 2/22/2007 **Drawing Number** This Issue : N/A Prsht Rev. : NC, Project Number . NA : MACHINED PARTS **Drawing Revision** First Issue : 30198 : NVA Material Previous Run Each **Due Date** : 3/20/2007 500 Um: Written By Checked & Approved By : Est E 02.08.29 Re-format; Removed finishing; Material changeK Comment J **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 303 Round Bar .75" M303R0750 1.0 Comment: Qty.: 0.0810 f(s)/Unit Total: 40.4775 f(s) Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch iourzy HARDINGE HARDINGE CNC LATHE SMALL Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Deburr and tumble INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC8 SECOND CHECK Comment: SECOND CHECK PACKAGING RESOURCE #1 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:__

Pade

17/1/14

Dart Aerospace Ltd

W/O:		WORK ORDER	R CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: ______ Date: _______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
	ATE STED Description of NC			Corrective Action Section B	Verification	A		
DATE	STEP	Section A	Initial Chief Eng		Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

QA: N/C Closed: ____ Date: ____

Date:

Thursday, 2/22/2007 2:57:28 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 30811

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



1050 Augs 27

Dart Aerospace Ltd

Date	Qty	Approval Chief Eng /	Τ_
		Chief Eng / Prod Mgr	Approva QC Inspector
_			4.

QA: N/C Closed: _____ Date: _____

NCR:	R: WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Annroval	Approval
DATE	STEP	STEP Description of NC Section A		Initial Action Description Sign & Chief Eng Chief Eng Date		Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30811
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	25,796				
0.060	+/-0.005	.058	-			
R0.010	+0.010/-0.000	JU15	-			
Ø0.425	+0.000/-0.002	. 424				
Ø0.257	+0.005/-0.000	.259				
Ø0.750	+/-0.010	.745				
0.030 x 20°	+/-0.010	7 ت-	<u>ا</u>			
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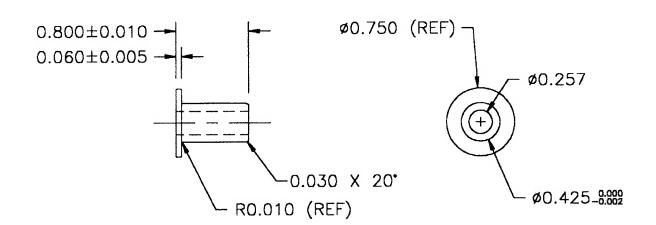
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Measured by: Sa	Audited by:	En	Prototype Approval:	N/A
Date: 01 05 on	Date:	07/05/64	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	atrice.
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	14



DESIGN	DRAWN BY	DART AEROSPA victoria international airr	
CHECKED	APPROVED	DRAWING NO.	REV. A
14	W	D2570	SHEET 1 OF 1
DATÉ		TITLE	SCALE
96:09:16		BUSHING	1:1

RELEASED



BREAK ALL SHARP CORNERS 0.010 MAX MATERIAL: AISI 303 - 0.75 DIA STOCK

X SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER